Quality Control

109766

Page 1

hursday, November 28, 2013 3:16:55 PM Item ID: D3265-041 Accept *N900040100* Setup Start Revision ID: Item Name: Basket Base Assembly Start Date: Start Qty: 1.00 11/28/2013 **Cust Item ID:** Required Date: 12/5/2013 Req'd Qty: 1.00 **Customer:** Reference: Run Date: \3-\\-28 Tooling: Process Plan: MC. Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** D3265 Е M 13-12-02 DAS 43 Weld per dwg A/R S.S. rod Batch: 0.00 M123823 Large Fab *4100* Large Fab 0.00 Large Fab 1- Assemble and weld as per Dwg D3265 using DT9444 2- Deburr and remove all markings from material as required 3- weld mesh as per dwg ***IF MAKING A D350-607-045A, CUT OFF ON ONE SIDE D2327-3 SPACER AS PER IIN-D350-607-145 SHEET 15*** QC9- Inspect visual per QSI004- Fusion Welds 13-12-03 0.00 Memo

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Thursday, November 28, 2013 3:16:55 PM Item ID: D3265-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Basket Base Assembly Start Date: 11/28/2013 Start Qty: 1.00 **Cust Item ID:** Required Date: 12/5/2013 **Req'd Qty:** 1.00 **Customer:** Reference: Run **Approvals:** Process Plan: **Tooling:** Date: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool # Plan Set Up/ Tool ID Reject Accept Work Center ID Description **Run Hours** Qty Qty Code 120 QC6- Inspect dimensions to drawing 0.00 *120* 13-12-03 0.00 Memo Quality Control White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 130 0.00 0.00

Powdercoat

Powder Coating

Memo

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OVEN TEMPERATUR

FINISH TIME:

2ND COAT:

START TIME: OVEN TEMPERATURE:

FINISH TIME:

****if necessary

1. \$ 13-12-3.

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DQA:			Date:										
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Thursday, November 28, 2013 3:16:55 PM

Page 3

Item ID: D3265-041 Accept *N900040100* Setup Start **Revision ID:** Basket Base Assembly Item Name: Start Date: 11/28/2013 Start Oty: 1.00 **Cust Item ID: Required Date: 12/5/2013** Req'd Qty: 1.00 *1* **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 140 QC3- Inspect Part Finish 0.00 *140* 17 0.00 Memo Quality Control 150 0.00 Small Fab *150* Small Fab 0.00 Memo 1x f Il istizlor Small Fab Seal support gusset seam with White Sikaflex-291 Batch: 11/127317 Expiry date: 1107 DAS 160 QC5- Inspect part completeness to step on W/O 0.00 27 *160* 0.00 Memo Quality Control

DQA: Date:	
WORK ORDER NON-CONFORMANCE / UPDATE	AEROSPACE
QA Closed: Date: Work Order update on	nly
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Part No. Scrap Machining Small Fab Prod. Eng. (
Use-as-is Thermoforming Finishing Rec/Store/Packa	
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Handling/Pre	
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Bending Bend Folio/Program Outside Dimensions	
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Cracks Broken/Damage/Defect Hardware Part Incorrect	Temperature/Cure
Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing	Weld
Cuffs Contamination Instructions Incomplete/Unclear Part Moved	Wrong Stock Pulled
Crushing Countersink Misaligned/off center Positioned Wrong	Other
Heat Treat Cut Too Short Mislabeled Power Loss/Surge	Other
Inspection Strip in Tube Drawing Misread	
Marks/Chatter Drill Holes Off-set Out of Calibration	
Wave/Twist in Tube Fit/Function Out of Sequence	

Thursday, November 28, 2013 3:16:55 PM Item ID: D3265-041 Revision ID: Basket Base Assembly Item Name:

Start Oty: 1.00 11/28/2013 Required Date: 12/5/2013 Req'd Oty: 1.00 *1*

Operation

Cust Item ID: Customer:

Reference:

Start Date:

Approvals: **Process Plan:**

QC:

Date: Date:

Tooling: SPC (Y/N):

Accept

Date: Date:

Tool # Plan

N900040100

Run

Stop

Setup Start

Sequence ID/ Work Center ID 170

Description Identify as per dwg & Stock Location: W \O Set Up/ **Run Hours**

D356-607-615/B109765 16 4 4/ 12/07

Tool ID

Accept Code Qty Qty

Reject Reject Insp. Number Stamp

170 Packaging

Packaging

Memo

0.00

180 QC

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

13/12/4 (A)

Quality Control

DQA:		_ Date:				. ~	ONIFOI	DRAABICE / I	IDDATE			DART
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	Wave/	Twist in Tu	be		Fit/Function		Out of	Sequence				

Picklist Print

Thursday, November 28, 2013 3:16:53 PM

Work Order ID:

109766

Parent Item:

D3265-041

Parent Item Name:

Basket Base Assembly

Start Date: 11/28/2013

Required Date: 12/5/2013

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:C Re-Format 05-11-03 JLM

IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verf: by:EC IPP RevE: as per DEO DD 10.09.12 verified by:EC IPP RevF: revise seq 110 DD 10.01.28 verified by:EC

IPP

	REV:G 12.07.26	AS PER DWG RE	V.D D	D VERF:EC		, aimie a o j i z							
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Thursday, November 28, 2013 3:16:54 PM

Work Order ID:

109766

Parent Item:

D3265-041

Parent Item Name:

Basket Base Assembly

Start Date: 11/28/2013

Required Date: 12/5/2013

Start Qty: 1.00

Required Qty: 1.00

Parent Item Name: Basket Bask	e Assembly					Star	t Qty: 1.00	Requir	ed Qty: 1.00	
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		Wave/Twist in Tube Fit/Function						Out of	Sequence				

Picklist Print

Thursday, November 28, 2013 3:16:54 PM

Work Order ID:

109766

Parent Item:

D3265-041

Parent Item Name:

Basket Base Assembly

D3832-11

Mesh (Base)

D3833-1 Mesh (Base End Face) Manufactured

Manufactured

No

100

100

Each

Each

0.0000

25.0000

Start Date: 11/28/2013

Start Qty: 1.00

08084 \rightarrow /x
2 OAS 13-11-29

Required Date: 12/5/2013

Required Qty: 1.00

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Location Loc Qty Loc Code WA004 25 105890 13 77521 81259 89208 99268

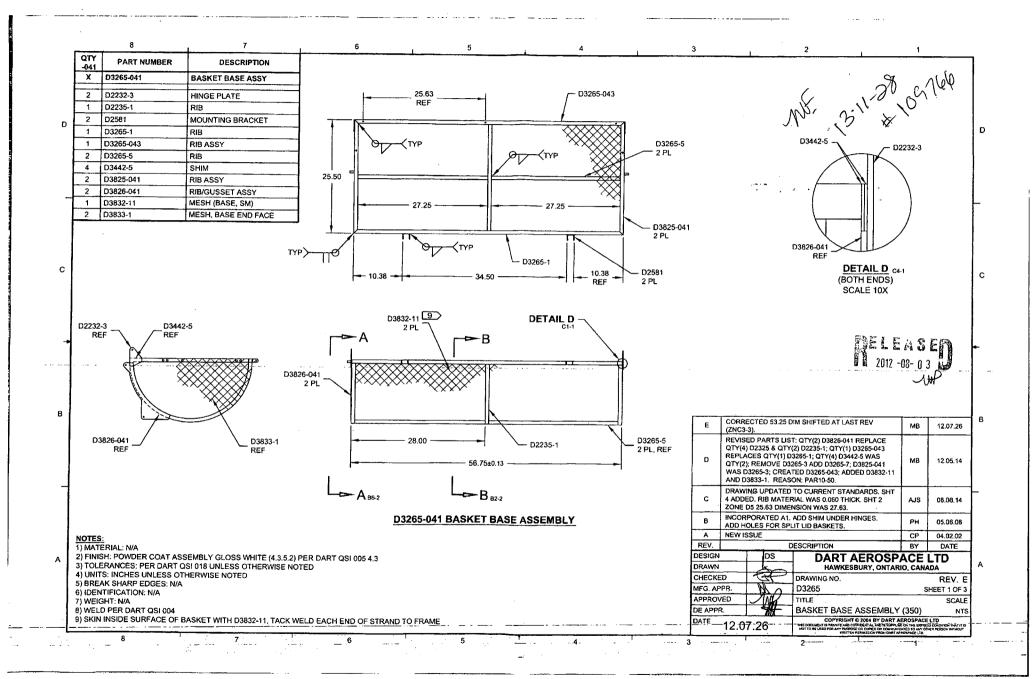
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Thursday, November 28, 2013 3:16:54 PM

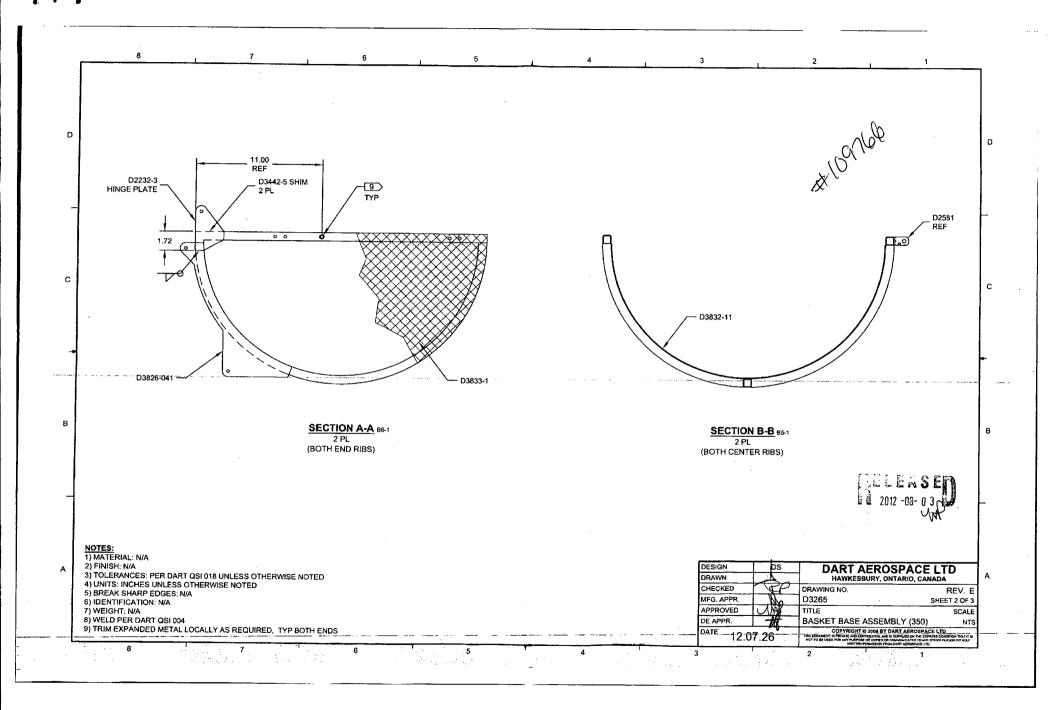
Shop Packet Print

Page 3

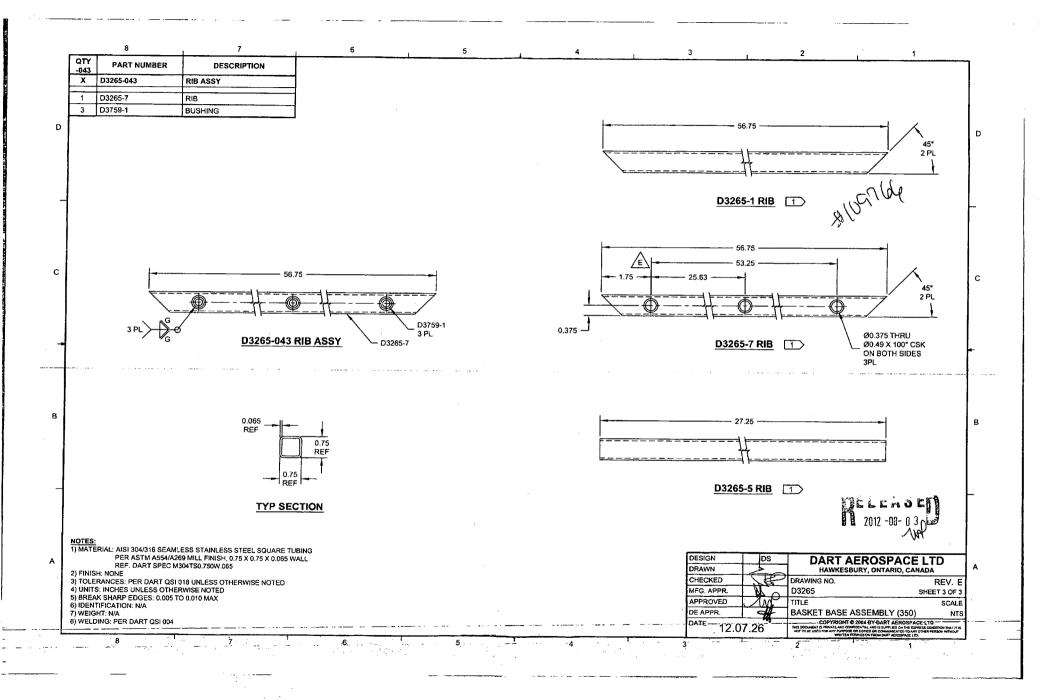
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					WORK ORDER NON	-CO	NFOF	RMANCE / UI				AEROSPACE
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ŀ				_	Use-as-is	1		noforming	Finishing		ore/Packaging	Other
NCR No.	•			· · · · · ·	Suspected Unapproved			Large Fab	Composite		Supplier	
Root				Desc	ription of work order update	Ir	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Chi	ef Eng	Descr	ription	Date	Verification	n QC Inspector
Design	_											
Doc/Data	4	1										
Equip/Tooling	4											
Handling/Pre	-				•		·			1		
Material	-				*					İ		
Operator]											
Offset/Setup	4				ц							
Process	-											
Supplier	4		ł							İ		
Training	╣	-	ļ			`						
Transport	-		1									
Unapproved		J	<u> </u>	<u> </u>		FΔU	ΙΙΤ CΔ1	I TEGORY				
Landing	Gear				General	170					•	
	Bending			Г	Bend		Folio/P	rogram	Г	Outside D	imensions	Pressure/Forced
	Centre N	ot Conce	ntric		BOM/Route	-	Grain			Over/Und	er tolerance 🦽	. Set-up
	Cracks				Broken/Damage/Defect	\vdash	Hardwa	ire	Ī	Part Incor	7	Temperature/Cure
	Cracks Crimp/Kink/Ripple/Wave				Burrs	П	Inspect	ion Incomplete/Ui	nqualified	Part Lost/	Missing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/U	Unclear	Part Move	ed	Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Positione	d Wrong	_
	Heat Treat				Cut Too Short		Mislabe	eled		Power Los	ss/Surge	Other
	Inspectio	n Strip in	Tube		Drawing		Misread	d			-	
	Marks/C	hatter			Drill Holes		Off-set					
	Turning	=			Finish			Calibration				
3	Wave/Tv	vist in Tu	be		Fit/Function		Out of	Sequence				



DQA:		Date:												$^{\sim}$ ar
					WORK ORDER NON	-CC	NFO	RMANCE / UF	PDATE					AEROSPACE
QA Closed:		Date:					·		****	Wo	ork Order up	date only		·
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
i voik orac	···				Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	0.				Scrap	1 1		Machining	Small Fab	-	Pro	d. Eng. Coor.	П	Quality
					Use-as-is]	Therm	noforming	Finishing		Rec/Stor	re/Packaging		Other
NCR N	lo				Suspected Unapproved]		Large Fab	Composite			Supplier		
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_	Centre N	ot Conce	entric	_	BOM/Route	Ш	Grain				Over/Under			Set-up
	Cracks				Broken/Damage/Defect	Ш	Hardwa	re		<u> </u>	Part Incorre		-	Temperature/Cure
	Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	<u> </u>	Part Lost/Mi	issing	$\boldsymbol{\vdash}$	Weld
	Cuffs				Contamination	-	ŀ	ions Incomplete/U	Jnclear		Part Moved		Ш	Wrong Stock Pulled
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	Heat Tre				Cut Too Short		Mislabe				Power Loss/	Surge	Ш	Other
	—	on Strip in	1 Tube	oxdot	Drawing	\vdash	Misread							
	Marks/C				Drill Holes	<u> </u>	Off-set							
		Sequence			Finish	<u> </u>	l .	Calibration				·		
	Wave/Tu	vist in Tu	be		Fit/Function		Out of 9	Sequence						



DQA:	Date:										
				WORK ORDER NON	-CC	ONFO	RMANCE / UPD	DATE			AEROSPACE
QA Closed:	Date:							W	ork Order up	date only	
We also Condens				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Order:			- 1	Daaut.	,		ماريم المنابع	C	1	Water Jet	
Dowt No.				Rework			—	Crosstube Small Fab	Dro	d. Eng. Coor.	Engineering Quality
Part No.				Scrap			Machining noforming	Finishing	4	e/Packaging	Other
NCR No.				Use-as-is Suspected Unapproved		mem		Composite	i Kec/Stoi	Supplier	
NCK NO.				Suspected Onapproved	1		raige rab	composite	J	Supplier	
Root			Desci	ription of work order update		nitial	Action	<u> </u>	Sign &		
Cause Da	te Step	Qty		or non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	QC Inspector
Design											
Doc/Data											
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Ben	-	. •	<u> </u>	Bend	-	1	Program		Outside Dim	- F	Pressure/Forced
) 	re Not Conce	ntric	-	BOM/Route	\vdash	Grain		├	Over/Under	F	Set-up Temperature/Cure
Crac			\vdash	Broken/Damage/Defect	\vdash	Hardwa		Lalified -	Part Incorre	- t	Weld
· —	p/Kink/Ripple -	e/ wave		Burrs	-	1 '	ion Incomplete/Unqu	<u> </u>	Part Moved	331118	Wrong Stock Pulled
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 	ning t Treat		\vdash	Cut Too Short	-	Mislabe	-	·	Power Loss/		Other
	ection Strip in	Tube		Drawing	-	Misrea			٦. ٥٠٠٠ د عمره	0- [1
· • • • • • • • • • • • • • • • • • • •	ks/Chatter		<u> </u>	Drill Holes		Off-set					
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	ing Sequence	!		Finish	\vdash	4	Calibration				



DQA:	Date:											TRACT
					WORK ORDER NON	I-CO	ONFO	RMANCE / UI	PDATE			AEROSPACE
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l	•				Rework	٦		Skid-tube	Crosstube	コ	Water Jet	Engineering
Part No).				Scrap	1		Machining	Small Fab	⊢ Pro	d. Eng. Coor.	Quality
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NCR No).				Suspected Unapproved							
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Root				Desc	ription of work order update		Initial	Act	ion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design												
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Landing	_	•			General]/r		Г	Outside Dim	Г	Pressure/Forced
	Bending	- . C			Bend BONA/Boute	\vdash	Grain	Program	-	Over/Under	-	Set-up
	Centre No	ot Conce	ntric	\vdash	BOM/Route	\vdash	Hardwa	aro.	-	Part Incorre		Temperature/Cure
	Cracks				Broken/Damage/Defect Burrs	\vdash	4	are ion Incomplete/Ur	ngualified	Part Lost/M	-	Weld
-	Crimp/Kink/Ripple/Wave				Contamination	\vdash	- 1 '	tions Incomplete/(· -	Part Moved	-	Wrong Stock Pulled
-	Cuffs Crushing				Countersink	-	-	gned/off center	-	Positioned V	L Vrong	
-	Heat Trea				Cut Too Short	\vdash	Mislab	-	F	Power Loss/		Other
 	Inspectio		Tuhe		Drawing		Misrea		L			
-	Marks/Ch	-			Drill Holes	\vdash	Off-set					
\	Turning S				Finish		-	Calibration				
	Wave/Twist in Tube Fit/Function						Out of	Sequence				